

**Work Order ID 64389**

Friday, December 03, 2010 11:39:41 AM



Page 1

Item ID: D206-802-023

Accept



Setup Start



Revisor ID:

Stop



Item Name: High Visibility Crew Door Opener Installation, LH/RH

Start Date: 12/3/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D407-802-2

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-802-023 CHG001

Sulzlos

CL 11-02-08

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/2/75 20

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sulzlos

(X2)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 64389**

Page 2

Friday, December 03, 2010 11:39:41 AM

Item ID: D206-802-023

Accept



Setup Start



Revision ID:

Stop



Item Name: High Visibility Crew Door Opener Installation, LH/RH

Start Date: 12/3/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description                               | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120                            |  | 0.00                 |         |        |              |               |               |                  |                |
|                                | Packaging  |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      | Identify and pack for shipping as per PPPDD206-802-023 |                      |         |        |              |               |               |                  |                |
|                                | Location: _____  |                      |         |        |              |               |               |                  |                |
|                                | PPP rev: _____   |                      |         |        |              |               |               |                  |                |
| 130                            |  | 0.00                 |         |        |              |               |               |                  |                |
|                                | QC21- Final Inspection - Work Order Release            |                      |         |        |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |

11/02/08

MF  
11-02-08

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 03, 2010 11:39:45 AM

Page 1

Work Order ID: 64389

Parent Item: D206-802-023

Parent Item Name: High Visibility Crew Door Opener Installation, LH/RH

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD ver:EC

| Component Item ID/<br>Item Name         | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty    | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| S <sub>2</sub> D3552-17<br>Door Prop    |                        | Manufactured  | No          |                     |                  | 105             | Each               | 1.0000         | 1           | 2               |               | 11/2/78        |        |
|   |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |        |
|   |                        |               |             | ST272A              |                  |                 |                    | 1              |             |                 |               |                |        |
|   |                        |               |             | 62271               |                  |                 |                    | 1              |             |                 |               |                |        |
| S <sub>2</sub> D3622-7<br>Ball Stud     |                        | Manufactured  | No          |                     |                  | 105             | Each               | 3.0000         | 2           | 4               |               | 11/2/78        |        |
|   |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |        |
|   |                        |               |             | ST070               |                  |                 |                    | 3              |             |                 |               |                |        |
|   |                        |               |             | 62406               |                  |                 |                    | 3              |             |                 |               |                |        |
| S <sub>2</sub> D4110-3<br>Doubler, Sill |                        | Manufactured  | No          |                     |                  | 105             | Each               | 0.0000         | 1           | 2               |               | 11/2/78        |        |
| S <sub>2</sub> D4111-3<br>Sill Fitting  |                        | Manufactured  | No          |                     |                  | 105             | Each               | 2.0000         | 1           | 2               |               | 11/2/78        |        |
|   |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |        |
|   |                        |               |             | ST129               |                  |                 |                    | 2              |             |                 |               |                |        |
|   |                        |               |             | 62300               |                  |                 |                    | 2              |             |                 |               |                |        |
| S <sub>2</sub> CR3523-4-4<br>Rivet      |                        | Purchased     | No          |                     |                  | 105             | Each               | 88.0000        | 2           | 4               |               | 11/2/78        | (20)   |
|   |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |        |
|   |                        |               |             | ST314               |                  |                 |                    | 88             |             |                 |               |                |        |
|   |                        |               |             | 115768              |                  |                 |                    | 88             |             |                 |               |                |        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 03, 2010 11:39:45 AM

Page 2

Work Order ID: 64389

Parent Item: D206-802-023

Parent Item Name: High Visibility Crew Door Opener Installation, LH/RH

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 2.00

Required Qty: 2.00

MS20426AD4-5

Purchased

No

105

Each

5,731.000

2

Rivet

## Location

## Loc Qty

## Loc Code

ST317

5731

6733

749

6874

4982

105

Each

350.0000

13

MS20600-AD4W2

Purchased

No

Rivet

## Location

## Loc Qty

## Loc Code

ST321

350

111359

50

112794

200

114348

100

105

Each

74.0000

1

MS21073L5

Purchased

No

nut plate

## Location

## Loc Qty

## Loc Code

ST303

74

113660

74

105

Each

19.0000

1

MS27039C5-11

Purchased

No

Screw

## Location

## Loc Qty

## Loc Code

ST293

19

115836

19

105

Each

0.0000

1

MS27130-A26

Purchased

No

Rivnut

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

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Friday, December 03, 2010 11:39:45 AM

Work Order ID: 64389



Parent Item: D206-802-023



Parent Item Name: High Visibility Crev. Door Opener Installation, LH/RH

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0563R

Purchased

No

105

Each

148.0000

2



Washer



11/27/10

20

Location

Loc Qty

Loc Code

ST297

148

115768

148

4

Friday, December 03, 2010 11:39:45 AM

Shop Packet Print

Page 3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

REFERENCE ONLY.

DART AEROSPACE LTD.

IIN-D206-802-2  
Page 23 of 25

## 5.0 PARTS LIST

### 5.1 D206-802-021/-022 Crew Door Opener Kits

| Qty<br>-021 | Qty<br>-022 | Part Number   | Description              |
|-------------|-------------|---------------|--------------------------|
|             |             | D206-802-021  | CREW DOOR OPENER KIT, LH |
|             |             | D206-802-022  | CREW DOOR OPENER KIT, RH |
| 1           | 1           | D3552-15      | DOOR PROP                |
| 2           | 2           | D3622-5       | BALL STUD                |
| 1           |             | D4110-1       | DOOR DOUBLER             |
|             | 1           | D4110-2       | DOOR DOUBLER             |
| 1           | 1           | D4110-3       | DOUBLER, SILL            |
| 5           | 5           | CR3242-4-2    | RIVET                    |
| 4           | 4           | MS20426AD4-5  | RIVET                    |
| 13          | 13          | MS20600AD4W2  | RIVET                    |
| 2           | 2           | MS21073L5     | ANCHOR NUT               |
| 1           | 1           | MS27130-A26   | RIVNUT (OR A10-130)      |
| 6           | 6           | NAS1149C0532R | WASHER                   |
| 6           | 6           | NAS1149C0563R | WASHER                   |

### 5.2 D206-802-023/-025 High Vis Crew Door Opener Kits

| Qty<br>-023 | Qty<br>-025 | Part Number   | Description                             |
|-------------|-------------|---------------|---|
|             |             | D206-802-023  | HIGH VIS CREW DOOR OPENER KIT, LH OR RH |
|             |             | D206-802-025  | HIGH VIS CREW DOOR OPENER RETROFIT KIT  |
| 1           | 1           | D3552-17      | DOOR PROP                               |
| 2           | 2           | D3622-7       | BALL STUD                               |
| 1           |             | D4110-3       | DOUBLER, SILL                           |
| 1           | 1           | D4111-3       | SILL FITTING                            |
| 2           | 2           | CR3523-4-4    | RIVET                                   |
| 2           |             | MS20426AD4-5  | RIVET                                   |
| 13          |             | MS20600AD4W2  | RIVET                                   |
| 1           |             | MS21073L5     | ANCHOR NUT                              |
| 1           | 1           | MS27039C5-11  | SCREW                                   |
| 1           |             | MS27130-A26   | RIVNUT (OR A10-130)                     |
| 2           | 2           | NAS1149C0563R | WASHER                                  |

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Revision: A  
Date: 10.10.13